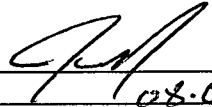
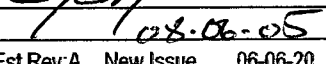


Date: Thursday, 05/06/2008 1:03:01 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 39723	
Estimate Number : 13092	
P.O. Number :	Part Number : D3492051
This Issue : 05/06/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 37289	Material :
Written By : 	Due Date : 12/06/2008 Qty: 20 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 06-06-20 JLM Est Rev:B as per Rev C 07-12-06 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0875	6061-T6 Round Bar .875"
-----	--------------	-------------------------



Comment: Qty.: 0.0481 f(s)/Unit Total: 0.9618 f(s)
6061-T6 Round Bar .875"
(M6061T6R0875)
Batch: M7950

J.F. 08/06/06 (24)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA714 & Dwg D3492
Dwg Rev: C
Folio Rev: AA

J.F. 08/06/06 (24)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/06/06 (24)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

AP 08/06/06 (24)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-~~debur~~ if necessary
1-~~debur~~ 2-Tumbler

EP 08/06/12 24

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39723

Part Number: D3492051

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(24)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/18 13

7.0

POWDER COATING

POWDER COATING



m107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

(24)

START TIME:

12:50

OVEN TEMPERATURE:

315

FINISH TIME:

1:20

11/12/18 08/06/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(24)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/19

9.0

NAS1611015

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-015 O-RING

m107178

FL

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(24)

Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: m102223

FL 08/06/20

11.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/20 724

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(24)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-01

FL 08/06/20

Date: Thursday, 05/06/2008 1:03:01 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39723

Part Number: D3492051

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE

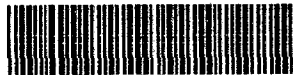


08/06/23

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

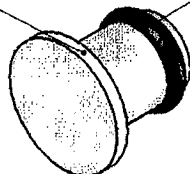
Job Completion



mf- 08-06-20

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



22/10/05

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

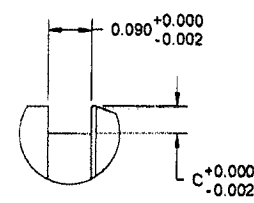
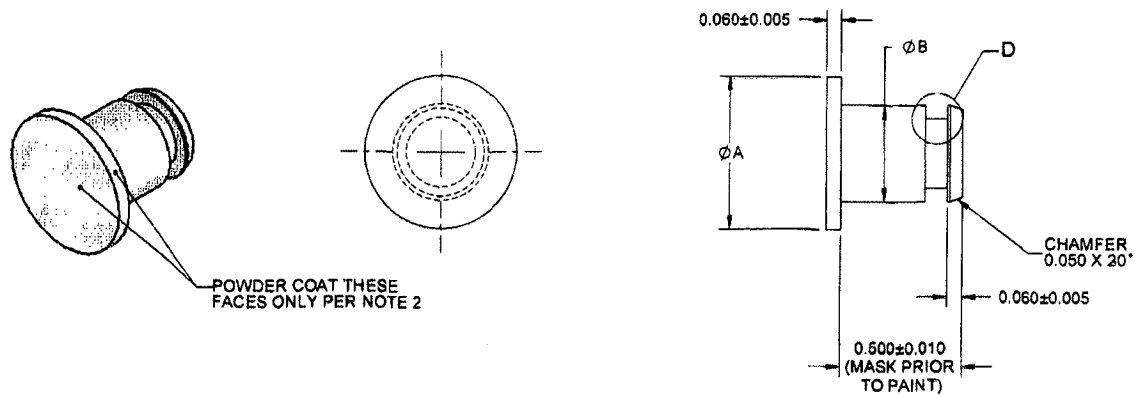
-051
06.06.05
UNDER REVIEW
01.04.05
DIM 01.04.05 D3492-13
REV. 02 (THREE SMALLER)

RELEASED
07.10.05

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3492	REV. C SHEET 1 OF 2
TITLE PLUG	SCALE 2:1
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8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

Eelbe op

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-8	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.864	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

- NOTES:**
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

-051
ref 03.06.05
UNDER REVIEW
01.04.11 RBA
DEM. 05 ON D3492-13
REV. 02 (WHICH SMALLER)

RELEASED
07.11.16

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		DRAWING NO. D3492
DATE	07.10.05	TITLE PLUG
		REV. C SHEET 2 OF 2 SCALE 4:1
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8 7 6 5 4 3 2 1

